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D3183-044
Job Sheet 186031



Part No: D3183-044

Job Qty: 4 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/8/18

Job Tracking No:

Due Date: 12/3/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C1 IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B Changed Mat Size 08-06-26 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	12/3/18	12/3/18	0.00	0.00	Start Up Machining-1		<i>KL 2018-12-02</i>
100	Bandsaw	4 pcs	12/3/18	12/3/18	0.00	0.06	Bandsaw1		<i>KL 2018-12-02</i>
110	CNC Vertical Machining	4 pcs	12/3/18	12/3/18	0.87	16.67	HAAS1-3		<i>KL 2018-12-02</i>
120	QC	4 pcs	12/3/18	12/3/18	0.00	0.00	QC2 Machining-1		<i>KL 2018-12-02</i>
130	QC	4 pcs	12/3/18	12/3/18	0.00	0.00	QC8 Machining-1		<i>KL 18-12-03</i>
140	Small Fab	4 pcs	12/3/18	12/3/18	0.00	0.21	Small Fab-3		<i>DAS 38</i>
150	QC	4 pcs	12/3/18	12/3/18	0.00	0.00	QC5		<i>DEC 06 2018</i>
160	Packaging	4 pcs	12/3/18	12/3/18	0.00	0.00	Packaging3-1	<i>51021</i>	<i>DEC 06 2018</i>
170	QC21-SA	4 Ea	12/3/18	12/3/18	0.00	0.00	QC21		<i>DEC 06 2018</i>

Part Op 100 - Cut blanks: (1.500" x 2.250") 5.500" long
Descriptions: 110 - 1-Machine D3183-4 as per Folio FA322 and Dwg D3183 Identify as D3183-4
140 - Assemble D3183-044 as per Dwg D3183.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.500X2.250	17-4 SS Bar 1.50 X2.250	1.8332 ft (.4583 ea)	90-Start up Operation	<i>5013645</i>
D3121-21	Bolt	8 Ea (2 ea)	140-Small Fab	<i>50972005X 5132955</i>
D3183-045	Bearing Assembly	8 Ea (2 ea)	140-Small Fab	<i>5134102</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-B1.500X2.250	2	3	0
140-Small Fab	D3121-21	8	5	0
	D3183-045	8	6	0

Part Specifications

Specifications could not be found.



Container No: S133769



Part: D3183-044

Job No: 186031

Serial No/Batch: S133769

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 12/02/16

DART AEROSPACE LTD		Work Order:	186031
Description: Bracket		Part Number:	D3183-4
Inspection Dwg: D3183 Rev: C1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	0.190	✓		R-G	
R0.063	+/-0.010	0.063	✓		"	
0.182	+/-0.010	0.182	✓		Kt.05	verm
0.070	+/-0.010	0.070	✓		"	
0.100	+/-0.010	0.100	✓		"	
Ø0.201 x 0.100	+/-0.010	0.2012.100	✓		Kt.05	verm.
0.182	+/-0.010	0.182	✓		"	
5.32	+/-0.030	5.327	✓		31006	H-G
5.036	+/-0.010	5.036	✓		"	
2.120	+/-0.010	2.120	✓		"	
1.290	+/-0.010	1.290	✓		"	
0.365	+/-0.010	0.366	✓		Kt.05	verm.
0.218	+/-0.010	0.216	✓		"	
1.030	+/-0.010	1.030	✓		"	
1.90	+/-0.030	1.885	✓		"	
1.012	+/-0.010	1.015	✓		31006	H-G
Ø0.201 x 0.100	+/-0.010	0.2012.100	✓		Kt.05	verm.
0.786	+/-0.010	0.786	✓		31006	H-G
Ø0.392	+0.002/-0.000	0.3935	✓		Kt.01	micrometre.
R0.19	+/-0.030	0.190	✓		R-G	
3.954	+/-0.010	3.954	✓		31006	H-G
0.162	+/-0.010	0.162	✓		Kt.01	micrometre
R0.19	+/-0.030	0.190	✓		R-G	
R0.25	+/-0.030	0.250	✓		"	
4.26	+/-0.030	4.26	✓		Kt.05	verm
2.800	+/-0.030	2.800	✓		"	
Calculated dimension	+/-0.030	2.800	✓		"	
0.162	+/-0.010	0.162	✓		"	
0.615	+/-0.010	0.615	✓		"	
0.435	+/-0.010	0.435	✓		"	
0.200	+/-0.010	0.200	✓		"	
0.381	+/-0.010	0.381	✓		"	
0.032	DAS +/-0.010	0.028	DAS		"	

Measured by:	1 9-89	Audited by:	20 9-89	Preliminary Approval:	N/A
Date:	2018-12-01	Date:	18-12-03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-044	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	04.06.15	Dimension 2.800 was 2.080; removed 1.155, 0.36 dimensions	KJ/JLM	
D	06.03.09	Dwg Rev update	KJ/JLM	
E	08.01.16	Dimensions revised	KJ/EC/DD	
F	10.09.23	Dimensions revised	KJ	

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